

Date: Thursday, 11/9/2006 4:38:41 PM
User: Kim Johnston

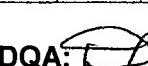
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STOP
Job Number	: 29406		
Estimate Number	: 10513		
P.O. Number	: N/A	Part Number	: D28052
This Issue	: 11/9/2006	Drawing Number	: D2805 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 29170	Material	: N/A
Written By	:	Due Date	: 11/24/2006
Checked & Approved By	: <u>SP 06/11/10</u>	Qty:	30
Comment	Um: Each		
	: Est: B 09/11/14 Revised Finishing step to Acid etch and		
	Alodine EC		

Additional Product

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1500X01500	6061-T6 Bar 1.5" x 1.5" 
		Comment: Qty.: 0.2756 f(s)/Unit Total : 8.2688 f(s) 6061-T6 Bar 1.5" x 1.5" Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5" (M6061T6B1500X01500) Batch: <u>M1695H</u>
2.0	BAND SAW	BAND SAW 
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
5.0	QC8	SECOND CHECK 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/11/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/9/2006 4:38:41 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 29406

Part Number: D28052

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

KFC 06/11/15 x30

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

PACKAGING RESOURCE #1

8.0 PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST387

PV 6/11/16

(30)

30

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/6/11/16

(30)

Job Completion



C Location 11/11/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29406
Description: Stop	Part Number:	D2805-2
Inspection Dwg: D2805 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.L.	Audited by:	<i>ml</i>	Prototype Approval:	N/A
Date:	06/11/13	Date:	<i>06/11/13</i>	Date:	N/A

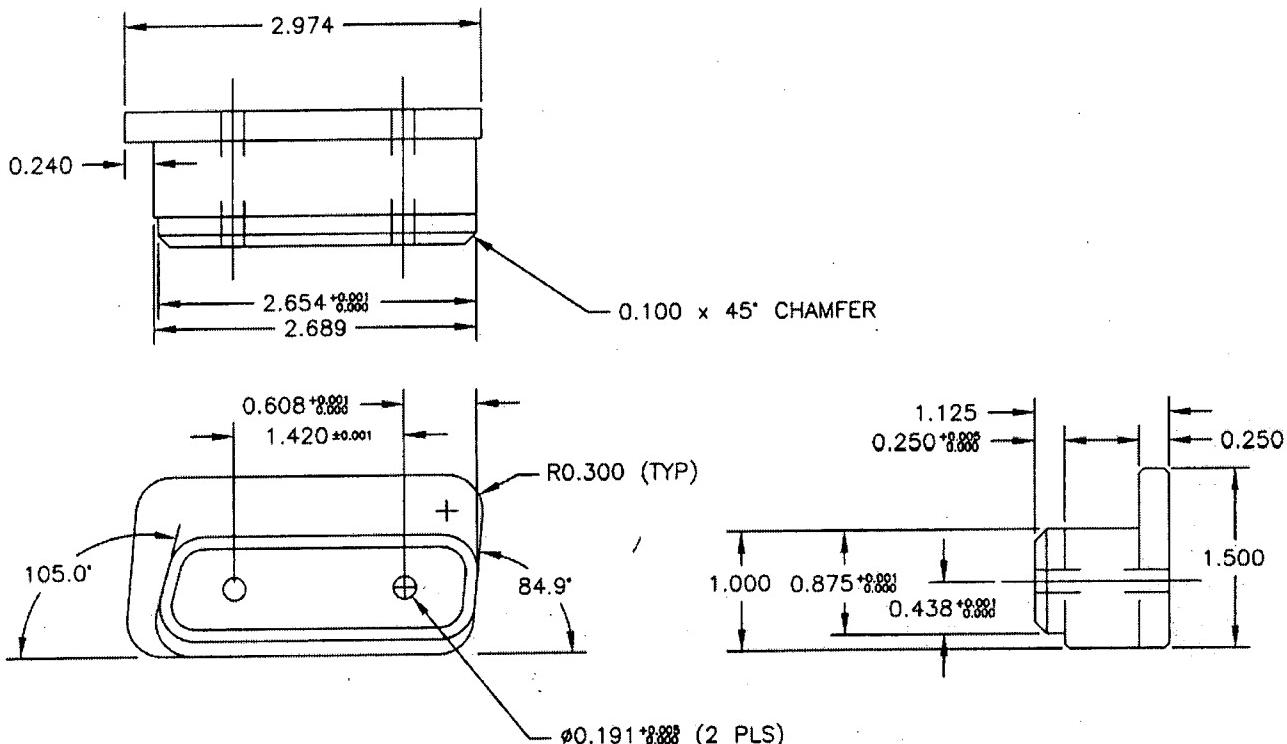
Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	SJM

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2805	SHEET 1 OF 2
DATE		TITLE	SCALE
01.03.13		STOP	2:3
A	00.10.31	NEW ISSUE	
B	01.03.13	ADD -3/-4	

RELEASED
01.03.16



D2805-1 (SHOWN)
D2805-2 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
 BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
 MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

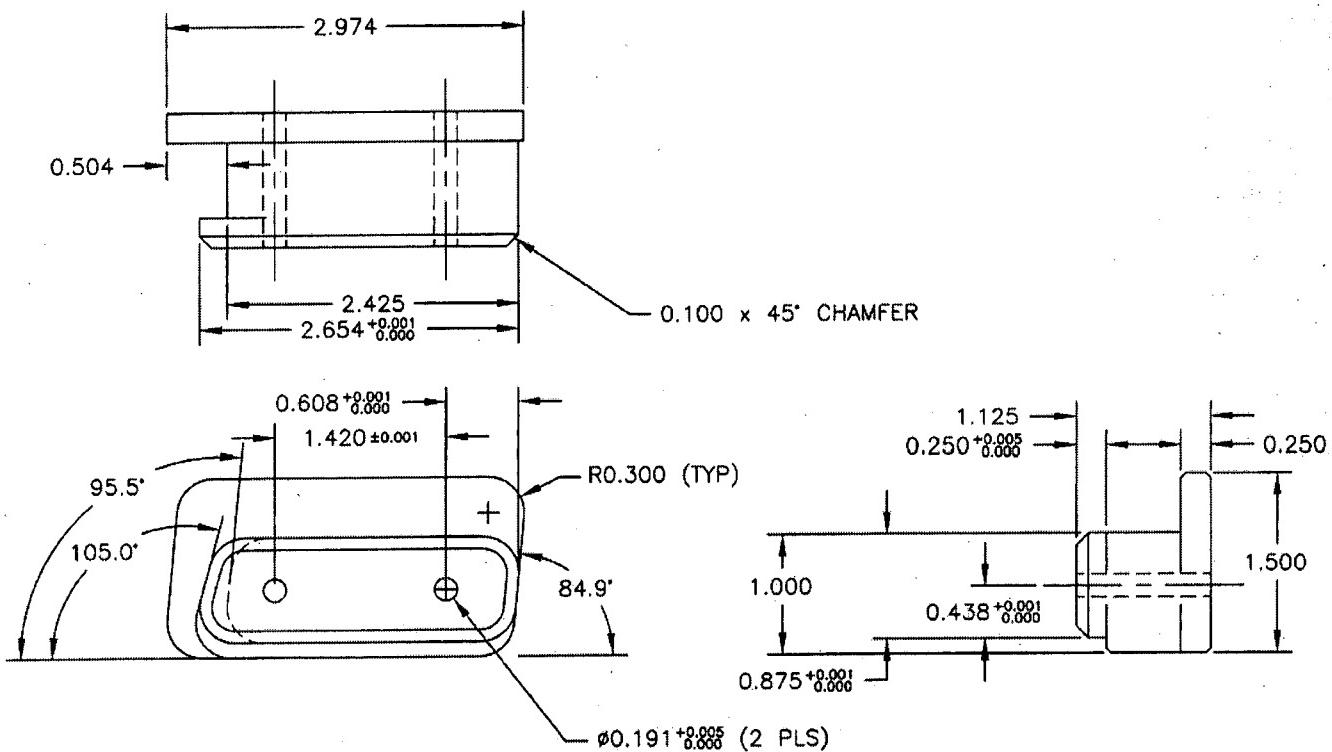
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WITHOUT NOTICE
WORK ORDER
NO. 29406

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DART

DESIGN	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED <i>CP</i>	DRAWING NO. D2805	REV. B SHEET 2 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3

RELEASED
01.03.16 *CP*

D2805-3 (SHOWN)
D2805-4 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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